

Work Order ID 91218

October-03-12 2:38:42 PM

91218

Page 1

Item ID: D2661-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 12/11/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-10-03 Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2661 | Rev E | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| *100* | HAAS CNC VERTICAL MACHINING #1 | | | | | | | | |
| HAAS 1 | Memo | 0.00 | | | | | | | |
| HAAS CNC vertical machine #1 | Program part number and batch number MACHINE AS PER DWG AND FOLIO FB071 | | | | | | | | |
| | FOLIO REV: <u>ML</u> | | | | | | | | |
| | DWG REV: <u>E</u> | | | | | | | | |
| 110 | | 0.00 | | | | | | | |
| *110* | CONVENTIONAL MILLING MACHINE | | | | | | | | |
| Mill Conv | Memo | 0.00 | | | | | | | |
| Conventional Milling Machine | Machine Keyway and inspect per attached dimension sheet | | | | | | | | |

DA
12-11-8

DAS
04
9-89

DA
12-11-P

DAS
04
9-89

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|------------------------------------|--|---|---|--------------------------|--|------------------------|---------------------|---|--|--|------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | | | | | | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | | | | | | | | | | | | | | | | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | | | | | | | | | | | | | | | | | | |

Work Order ID 91218

91218

Page 2

Item ID: D2661-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 12/11/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|----------------|--------------|---------------|---------------|------------------|-------------------|
| 120 *120* QC Quality Control | QC2- Inspect parts off machine FAI/FAIB Memo | 0.00 0.00 | | 12-11-8 | | | | | DAS 04 9-89 |
| 130 *130* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | ent 12/11/12 | | 30 | | | DAS 14 9-89 |
| 140 *140* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | 30 NB 12/11/12 | | | | | |

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | |
|--|-------------|-------------|------------|---|--------------------------|-----------------------------------|------------------------|---------------------|---------------------|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION <div style="display: flex; justify-content: space-around;"> Rework <input type="checkbox"/> Skid-tube <input type="checkbox"/> Crosstube <input type="checkbox"/> Water Jet <input type="checkbox"/> Engineering <input type="checkbox"/> </div> <div style="display: flex; justify-content: space-around;"> Scrap <input type="checkbox"/> Machining <input type="checkbox"/> Small Fab <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Quality <input type="checkbox"/> </div> <div style="display: flex; justify-content: space-around;"> Use-as-is <input type="checkbox"/> Thermoforming <input type="checkbox"/> Finishing <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Other <input type="checkbox"/> </div> <div style="display: flex; justify-content: space-around;"> Work Order Update <input type="checkbox"/> Large Fab <input type="checkbox"/> Composite <input type="checkbox"/> Supplier <input type="checkbox"/> </div> | | AGAINST DEPARTMENT/PROCESS | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | |

| FAULT CATEGORY | | | | |
|---|---|---|--|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

Work Order ID 91218

91218

October-03-12 2:38:42 PM

Item ID: D2661-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 12/11/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

Powder Coating

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

Quality Control

170

Identify as per dwg & Stock Location:

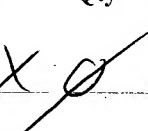
0.00


170


Packaging

Memo

Packaging

30X 


12/11/12

30  12-11-12



8 12/11/12

m 122878

1-40
3200F

2-10

432

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | |
|---|-------------|-------------|---|---|--------------------------|---|------------------------|---------------------|---|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | | |

Work Order ID 91218

October-03-12 2:38:42 PM

91218

Page 4

Item ID: D2661-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 12/11/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/11/13 *dg*
CMF
12-11-13

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | |
|--|------|------|-----|---|----------------------|---|----------------|--------------|--------------|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |

| FAULT CATEGORY | | | |
|---|---|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

Picklist Print

October-03-12 2:38:45 PM

Page 1

Work Order ID: 91218

91218

Parent Item: D2661-2

D2661-2

Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 03/10/2012

Required Date: 12/11/2012

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP: C00.11.01Removed P/O for Powder Coat - in house

processEC

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

IPP Rev:D As per Rev D 07-03-19 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6101-003 | | Manufactured | No | | | 100 | Each | 24.0000 | 1 | 30 | | | |

D6101-003

Saddle Billet, 7075

**

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT040 | 26 | |
| 73775 | 2 | |
| 73780 | 7 | |
| 78599 | 10 | |
| 80765 | 0 | |
| MAT042 | -3 | |
| 87498 | 4 | |
| MAT044 | 1 | |
| 73769 | 1 | |
| 91237 | | |

30

FK 12/11/06.

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | |
|--|-------------|-------------|------------|---|--------------------------|---|------------------------|---------------------|---------------------|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | |

| FAULT CATEGORY | | | | |
|--|---|---|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | |

| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 91218 |
| Description: 206 Saddle, Outboard, Right side | | Part Number: | D2661-2 |
| Inspection Dwg: D2661 Rev: E DSK: Rev: | | Page 1 of 1 | |

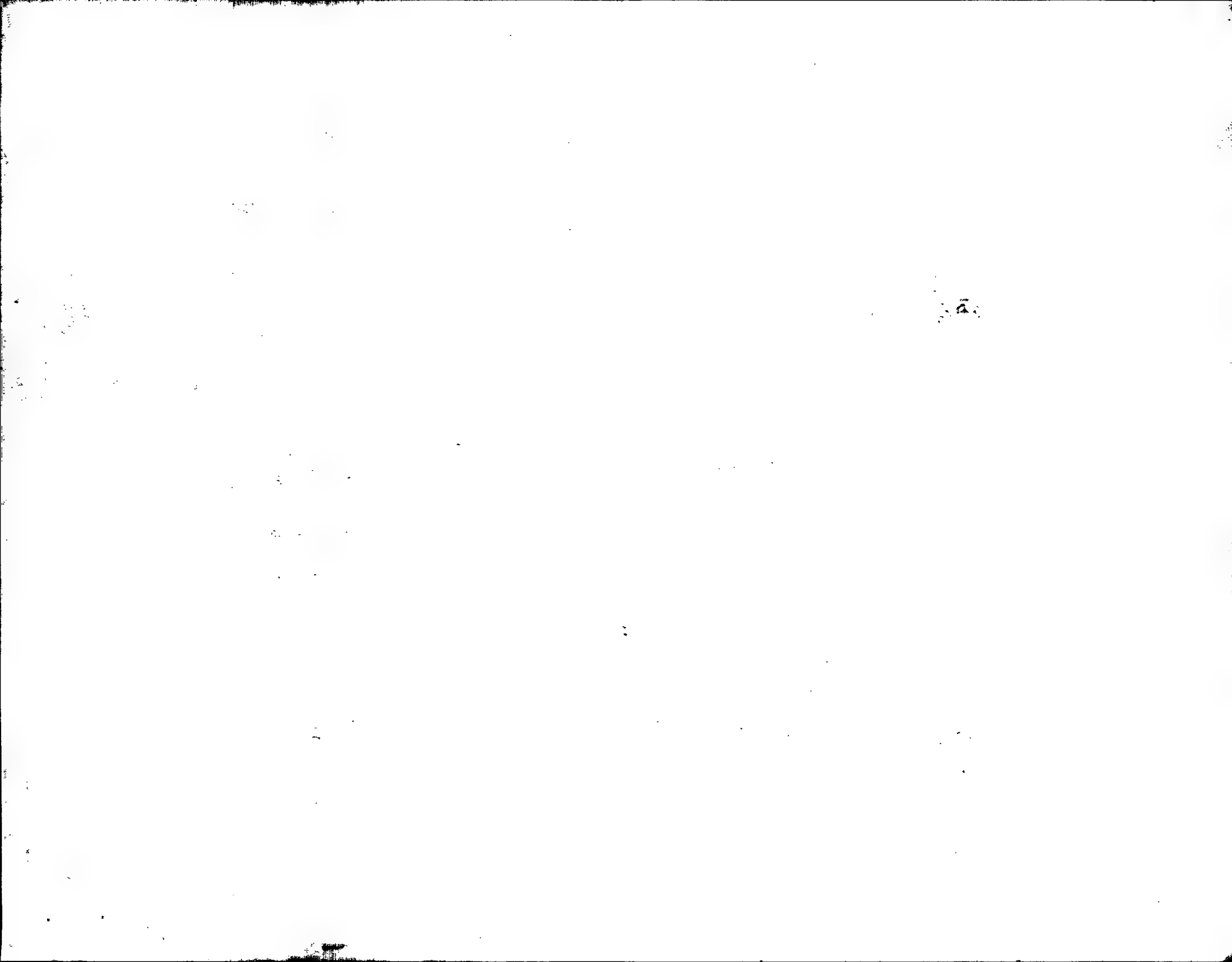
FIRST ARTICLE INSPECTION DIMENSION SHEET

| Dim | Min | Max | Go/No Go Gauge | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|--------|-------|-------|-------|
| | | | | 1 | 2 | 3 | 4 | 5 |
| A | 3.611 | 3.621 | | 3.616 | 3.616 | 3.616 | 3.616 | 3.616 |
| B | 0.256 | 0.263 | | .258 | .258 | .258 | .258 | .258 |
| C | 0.315 | 0.322 | | .316 | .316 | .316 | .316 | .316 |
| D | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 |
| E | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | 1.679 |
| F | 1.357 | 1.367 | | 1.362 | 1.362 | 1.362 | 1.362 | 1.362 |
| G | 0.100 | 0.140 | | .124 | .125 | .124 | .123 | .123 |
| H | 0.210 | 0.230 | | .228 | .225 | .225 | .222 | .219 |
| I | 0.615 | 0.685 | | .680 | .680 | .680 | .680 | .680 |
| J | 2.470 | 2.510 | | 2.490 | 2.491 | 2.491 | 2.491 | 2.491 |
| K | 1.313 | 1.343 | | 1.328 | 1.324 | 1.323 | 1.323 | 1.323 |
| L | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | .188 |
| M | 0.470 | 0.530 | | .500 | .500 | .500 | .500 | .500 |
| N | 1.125 | 1.145 | | 1.1355 | 1.1375 | 1.136 | 1.136 | 1.131 |
| O | 0.100 | 0.180 | | .135 | .135 | .135 | .135 | .135 |
| P | 0.100 | 0.140 | | .135 | .132 | .130 | .130 | .130 |
| Q | 0.240 | 0.260 | | .254 | .249 | .249 | .246 | .251 |
| R | 0.677 | 0.697 | | .687 | .687 | .687 | .690 | .690 |
| S | 0.100 | 0.140 | | .130 | .127 | .127 | .125 | .130 |
| T | 1.565 | 1.585 | | 1.576 | 1.578 | 1.576 | 1.576 | 1.575 |
| U | 0.540 | 0.560 | | .550 | .550 | .550 | .548 | .548 |
| V | 0.912 | 0.932 | | .922 | .922 | .922 | .925 | .925 |
| W | 0.787 | 0.807 | | .797 | .797 | .797 | .796 | .796 |
| X | 5.990 | 6.010 | | 6.000 | 6.000 | 6.000 | 6.000 | 6.000 |
| Y | 4.995 | 5.005 | | 5.000 | 5.000 | 5.000 | 5.000 | 5.000 |
| Z | 0.490 | 0.510 | | .499 | .498 | .497 | .500 | .497 |
| AA | 0.312 | 0.319 | | .314 | .314 | .314 | .314 | .314 |
| AB | 0.990 | 1.010 | | 1.000 | 1.000 | 1.000 | 1.000 | 1.000 |
| AC | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 |
| AD | 0.490 | 0.510 | | .503 | .503 | .503 | .503 | .503 |
| AE | 3.745 | 3.755 | | 3.750 | 3.750 | 3.750 | 3.750 | 3.750 |
| AF | 0.235 | 0.240 | | .238 | .237 | .237 | .238 | .238 |
| AG | 0.510 | 0.515 | | .512 | .512 | .512 | .513 | .513 |
| AH | 0.100 | 0.120 | | .114 | .113 | .113 | .113 | .113 |
| Accept/Reject | | | | | | | | |

| | |
|----------------------------|----------|
| Measured by: | FKAS/Rel |
| Audited by: | 14 con |
| Prototype Approval: | 2-83 |

| | |
|--------------|---------------------|
| Date: | 12/11/07 / 12-11-08 |
| Date: | 12/11/12 |
| Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------------------------|------------|----------|
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |
| G | 11.11.07 | Dimensions C and F revised | KJ | |
| H | 12.01.10 | Revised per drawing revision E | KJ | AI |



| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 91218 |
| Description: 206 Saddle, Outboard, Right side | | Part Number: | D2661-2 |
| Inspection Dwg: D2661 Rev: E DSK: Rev: | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION DIMENSION SHEET

| Dim | Min | Max | Go/No Go Gauge | Record Actual Dimensions | | | | |
|-----|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| | | | | 16 | 17 | 18 | 19 | 20 |
| A | 3.611 | 3.621 | | 3.616 | 3.616 | 3.616 | 3.616 | 3.616 |
| B | 0.256 | 0.263 | | .258 | .258 | .258 | .258 | .258 |
| C | 0.315 | 0.322 | | .316 | .316 | .316 | .316 | .316 |
| D | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 |
| E | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | 1.679 |
| F | 1.357 | 1.367 | | 1.362 | 1.362 | 1.362 | 1.362 | 1.362 |
| G | 0.100 | 0.140 | | .123 | .123 | .123 | .123 | .123 |
| H | 0.210 | 0.230 | | .220 | .220 | .220 | .220 | .220 |
| I | 0.615 | 0.685 | | .680 | .680 | .680 | .680 | .680 |
| J | 2.470 | 2.510 | | 2.490 | 2.490 | 2.490 | 2.490 | 2.490 |
| K | 1.313 | 1.343 | | 1.323 | 1.323 | 1.323 | 1.323 | 1.323 |
| L | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | .188 |
| M | 0.470 | 0.530 | | .50 | .50 | .50 | .50 | .50 |
| N | 1.125 | 1.145 | | 1.135 | 1.135 | 1.135 | 1.135 | 1.135 |
| O | 0.100 | 0.180 | | .135 | .135 | .135 | .135 | .135 |
| P | 0.100 | 0.140 | | .130 | .130 | .130 | .130 | .130 |
| Q | 0.240 | 0.260 | | .245 | .245 | .245 | .247 | .247 |
| R | 0.677 | 0.697 | | .686 | .686 | .686 | .686 | .686 |
| S | 0.100 | 0.140 | | .123 | .123 | .123 | .123 | .123 |
| T | 1.565 | 1.585 | | 1.575 | 1.575 | 1.575 | 1.575 | 1.575 |
| U | 0.540 | 0.560 | | .548 | .548 | .548 | .548 | .548 |
| V | 0.912 | 0.932 | | .922 | .922 | .922 | .922 | .922 |
| W | 0.787 | 0.807 | | .797 | .797 | .797 | .797 | .797 |
| X | 5.990 | 6.010 | | 6.000 | 6.000 | 6.000 | 6.000 | 6.000 |
| Y | 4.995 | 5.005 | | 5.000 | 5.000 | 5.000 | 5.000 | 5.000 |
| Z | 0.490 | 0.510 | | .50 | .50 | .50 | .50 | .50 |
| AA | 0.312 | 0.319 | | .314 | .314 | .314 | .314 | .314 |
| AB | 0.990 | 1.010 | | 1.000 | 1.000 | 1.000 | 1.000 | 1.000 |
| AC | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 |
| AD | 0.490 | 0.510 | | .500 | .500 | .500 | .500 | .500 |
| AE | 3.745 | 3.755 | | 3.750 | 3.750 | 3.750 | 3.750 | 3.750 |
| AF | 0.235 | 0.240 | | .237 | .237 | .237 | .237 | .237 |
| AG | 0.510 | 0.515 | | .513 | .513 | .513 | .513 | .513 |
| AH | 0.100 | 0.120 | | .112 | .112 | .112 | .112 | .112 |

Accept/Reject

| | |
|--|------------------------------|
| Measured by: <i>[Signature]</i> DAS 104 8-83 | Date: <i>11-9</i> |
| Audited by: <i>[Signature]</i> 14 9-83 | Date: <i>12/11/12</i> |
| Prototype Approval: <i>[Signature]</i> | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------------------------|-----------------------|--------------------|
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |
| G | 11.11.07 | Dimensions C and F revised | KJ | |
| H | 12.01.10 | Revised per drawing revision E | KJ <i>[Signature]</i> | <i>[Signature]</i> |

| | | | |
|--|---------------|---------------------|--------------------|
| DART AEROSPACE LTD | | Work Order: | 91218 |
| Description: 206 Saddle, Outboard, Right side | | Part Number: | D2661-2 |
| Inspection Dwg: D2661 | Rev: E | DSK: | Rev: |
| | | | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

| Dim | Min | Max | Go/No Go Gauge | Record Actual Dimensions | | | | |
|-----|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| | | | | 1 | 2 | 3 | 4 | 5 |
| A | 3.611 | 3.621 | | 3.616 | 3.616 | 3.616 | 3.616 | 3.616 |
| B | 0.256 | 0.263 | | .258 | .258 | .258 | .258 | .258 |
| C | 0.315 | 0.322 | | .315 | .316 | .316 | .316 | .316 |
| D | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 |
| E | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | 1.679 |
| F | 1.357 | 1.367 | | 1.362 | 1.362 | 1.362 | 1.362 | 1.362 |
| G | 0.100 | 0.140 | | .122 | .122 | .122 | .129 | .124 |
| H | 0.210 | 0.230 | | .220 | .221 | .220 | .222 | .220 |
| I | 0.615 | 0.685 | | .680 | .680 | .680 | .680 | .680 |
| J | 2.470 | 2.510 | | 2.490 | 2.490 | 2.490 | 2.490 | 2.490 |
| K | 1.313 | 1.343 | | 1.323 | 1.323 | 1.323 | 1.328 | 1.323 |
| L | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | .188 |
| M | 0.470 | 0.530 | | .50 | .50 | .50 | .50 | .50 |
| N | 1.125 | 1.145 | | 1.135 | 1.135 | 1.135 | 1.136 | 1.135 |
| O | 0.100 | 0.180 | | .135 | .135 | .135 | .135 | .135 |
| P | 0.100 | 0.140 | | .130 | .130 | .130 | .128 | .129 |
| Q | 0.240 | 0.260 | | .245 | .245 | .247 | .246 | .247 |
| R | 0.677 | 0.697 | | .689 | .689 | .689 | .689 | .689 |
| S | 0.100 | 0.140 | | .125 | .125 | .125 | .120 | .122 |
| T | 1.565 | 1.585 | | 1.575 | 1.575 | 1.570 | 1.576 | 1.575 |
| U | 0.540 | 0.560 | | .548 | .548 | .548 | .548 | .548 |
| V | 0.912 | 0.932 | | .921 | .921 | .921 | .919 | .923 |
| W | 0.787 | 0.807 | | .796 | .796 | .796 | .799 | .796 |
| X | 5.990 | 6.010 | | 6.000 | 6.000 | 6.000 | 6.000 | 6.000 |
| Y | 4.995 | 5.005 | | 5.000 | 5.000 | 5.000 | 5.000 | 5.000 |
| Z | 0.490 | 0.510 | | .497 | .497 | .497 | .501 | .503 |
| AA | 0.312 | 0.319 | | .314 | .314 | .314 | .314 | .314 |
| AB | 0.990 | 1.010 | | 1.000 | 1.000 | 1.000 | 1.000 | 1.000 |
| AC | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 |
| AD | 0.490 | 0.510 | | .500 | .500 | .500 | .500 | .500 |
| AE | 3.745 | 3.755 | | 3.750 | 3.750 | 3.750 | 3.750 | 3.750 |
| AF | 0.235 | 0.240 | | .237 | .237 | .237 | .238 | .236 |
| AG | 0.510 | 0.515 | | .514 | .514 | .514 | .512 | .512 |
| AH | 0.100 | 0.120 | | .112 | .112 | .112 | .113 | .111 |

Accept/Reject

| | |
|-----------------------------------|-----------------------|
| Measured by: <i>29 DAS</i> | Date: 12.11.9 |
| Audited by: <i>14 AX</i> | Date: 12/11/12 |
| Prototype Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------------------------|------------|----------|
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |
| G | 11.11.07 | Dimensions C and F revised | KJ | |
| H | 12.01.10 | Revised per drawing revision E | KJ | |

| | | | | | |
|--|--|--|--|-----------------------------|--|
| DART AEROSPACE LTD | | | | Work Order: 91218 | |
| Description: 206 Saddle, Outboard, Right side | | | | Part Number: D2661-2 | |
| Inspection Dwg: D2661 Rev: E DSK: Rev: | | | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION DIMENSION SHEET

| Dim | Min | Max | Go/No Go Gauge | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| | | | | #16 | #17 | #18 | #19 | #20 |
| A | 3.611 | 3.621 | | 3.616 | 3.616 | 3.616 | 3.616 | 3.616 |
| B | 0.256 | 0.263 | | .256 | .256 | .256 | .256 | .256 |
| C | 0.315 | 0.322 | | .316 | .316 | .316 | .316 | .316 |
| D | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 |
| E | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | 1.679 |
| F | 1.357 | 1.367 | | 1.362 | 1.362 | 1.362 | 1.362 | 1.362 |
| G | 0.100 | 0.140 | | .124 | .124 | .123 | .122 | .125 |
| H | 0.210 | 0.230 | | .221 | .220 | .220 | .222 | .220 |
| I | 0.615 | 0.685 | | .680 | .680 | .680 | .680 | .680 |
| J | 2.470 | 2.510 | | 2.490 | 2.490 | 2.490 | 2.490 | 2.490 |
| K | 1.313 | 1.343 | | 1.325 | 1.324 | 1.323 | 1.326 | 1.325 |
| L | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | .188 |
| M | 0.470 | 0.530 | | .500 | .500 | .500 | .500 | .500 |
| N | 1.125 | 1.145 | | 1.136 | 1.135 | 1.138 | 1.137 | 1.137 |
| O | 0.100 | 0.180 | | .135 | .135 | .135 | .135 | .135 |
| P | 0.100 | 0.140 | | .132 | .130 | .133 | .130 | .130 |
| Q | 0.240 | 0.260 | | .245 | .248 | .248 | .246 | .244 |
| R | 0.677 | 0.697 | | .691 | .691 | .687 | .691 | .687 |
| S | 0.100 | 0.140 | | .124 | .124 | .122 | .125 | .124 |
| T | 1.565 | 1.585 | | 1.576 | 1.575 | 1.577 | 1.577 | 1.577 |
| U | 0.540 | 0.560 | | .547 | .547 | .547 | .548 | .546 |
| V | 0.912 | 0.932 | | .924 | .922 | .924 | .923 | .921 |
| W | 0.787 | 0.807 | | .796 | .797 | .799 | .797 | .797 |
| X | 5.990 | 6.010 | | 6.000 | 6.000 | 6.000 | 6.000 | 6.000 |
| Y | 4.995 | 5.005 | | 5.000 | 5.000 | 5.000 | 5.000 | 5.000 |
| Z | 0.490 | 0.510 | | .500 | .502 | .497 | .498 | .497 |
| AA | 0.312 | 0.319 | | .314 | .314 | .314 | .314 | .314 |
| AB | 0.990 | 1.010 | | 1.000 | 1.000 | 1.000 | 1.000 | 1.000 |
| AC | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 |
| AD | 0.490 | 0.510 | | .500 | .500 | .500 | .500 | .500 |
| AE | 3.745 | 3.755 | | 3.750 | 3.750 | 3.750 | 3.750 | 3.750 |
| AF | 0.235 | 0.240 | | .235 | .236 | .236 | .237 | .236 |
| AG | 0.510 | 0.515 | | .514 | .510 | .511 | .511 | .512 |
| AH | 0.100 | 0.120 | | .110 | .111 | .111 | .111 | .110 |
| Accept/Reject | | | | | | | | |

| | |
|----------------------------------|-----------------------|
| Measured by: <i>BT 02</i> | Date: 12/11/11 |
| Audited by: <i>mx 14</i> | Date: 12/11/12 |
| Prototype Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------------------------|------------|----------|
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |
| G | 11.11.07 | Dimensions C and F revised | KJ | |
| H | 12.01.10 | Revised per drawing revision E | KJ | |

| | | | | | |
|--|--|--|--|-----------------------------|--|
| DART AEROSPACE LTD | | | | Work Order: 91218 | |
| Description: 206 Saddle, Outboard, Right side | | | | Part Number: D2661-2 | |
| Inspection Dwg: D2661 Rev: E DSK: Rev: | | | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION DIMENSION SHEET

| Dim | Min | Max | Go/No Go Gauge | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| | | | | 21 | 22 | 23 | 24 | 25 |
| A | 3.611 | 3.621 | | 3.616 | 3.616 | 3.616 | 3.616 | 3.616 |
| B | 0.256 | 0.263 | | .258 | .258 | .258 | .258 | .258 |
| C | 0.315 | 0.322 | | .316 | .316 | .316 | .316 | .316 |
| D | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 |
| E | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | 1.679 |
| F | 1.357 | 1.367 | | 1.362 | 1.362 | 1.362 | 1.362 | 1.362 |
| G | 0.100 | 0.140 | | .125 | .124 | .125 | .125 | .126 |
| H | 0.210 | 0.230 | | .221 | .221 | .222 | .221 | .222 |
| I | 0.615 | 0.685 | | .680 | .680 | .680 | .680 | .680 |
| J | 2.470 | 2.510 | | 2.490 | 2.490 | 2.490 | 2.490 | 2.490 |
| K | 1.313 | 1.343 | | 1.325 | 1.324 | 1.323 | 1.323 | 1.325 |
| L | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | .188 |
| M | 0.470 | 0.530 | | .500 | .500 | .500 | .500 | .500 |
| N | 1.125 | 1.145 | | 1.138 | 1.138 | 1.137 | 1.138 | 1.139 |
| O | 0.100 | 0.180 | | .135 | .135 | .135 | .135 | .135 |
| P | 0.100 | 0.140 | | .130 | .132 | .128 | .129 | .128 |
| Q | 0.240 | 0.260 | | .247 | .244 | .243 | .246 | .244 |
| R | 0.677 | 0.697 | | .691 | .691 | .689 | .689 | .689 |
| S | 0.100 | 0.140 | | .123 | .126 | .121 | .124 | .126 |
| T | 1.565 | 1.585 | | 1.579 | 1.579 | 1.577 | 1.578 | 1.580 |
| U | 0.540 | 0.560 | | .549 | .548 | .544 | .546 | .546 |
| V | 0.912 | 0.932 | | .921 | .923 | .918 | .921 | .921 |
| W | 0.787 | 0.807 | | .797 | .799 | .797 | .799 | .797 |
| X | 5.990 | 6.010 | | 6.000 | 6.000 | 6.000 | 6.000 | 6.000 |
| Y | 4.995 | 5.005 | | 5.000 | 5.000 | 5.000 | 5.000 | 5.000 |
| Z | 0.490 | 0.510 | | .498 | .497 | .495 | .501 | .495 |
| AA | 0.312 | 0.319 | | .314 | .314 | .314 | .314 | .314 |
| AB | 0.990 | 1.010 | | 1.000 | 1.000 | 1.000 | 1.000 | 1.000 |
| AC | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 |
| AD | 0.490 | 0.510 | | .500 | .500 | .500 | .500 | .500 |
| AE | 3.745 | 3.755 | | 3.750 | 3.750 | 3.750 | 3.750 | 3.750 |
| AF | 0.235 | 0.240 | | .236 | .237 | .235 | .236 | .236 |
| AG | 0.510 | 0.515 | | .512 | .512 | .512 | .512 | .512 |
| AH | 0.100 | 0.120 | | .111 | .112 | .110 | .111 | .111 |
| Accept/Reject | | | | | | | | |

| | |
|--------------------------------|-----------------------|
| Measured by: JET 021-AS | Date: 12 11 11 |
| Audited by: [Signature] | Date: 12/11/12 |
| Prototype Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------------------------|------------|-------------|
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |
| G | 11.11.07 | Dimensions C and F revised | KJ | |
| H | 12.01.10 | Revised per drawing revision E | KJ | [Signature] |

| | | | |
|--|---------------|---------------------|-------------|
| DART AEROSPACE LTD | | Work Order: | 91218 |
| Description: 206 Saddle, Outboard, Right side | | Part Number: | D2661-2 |
| Inspection Dwg: D2661 | Rev: E | DSK: | Rev: |
| | | | Page 1 of 1 |

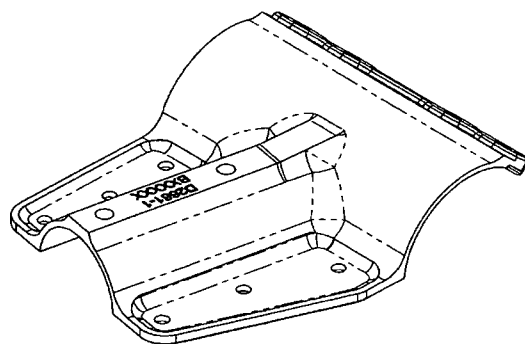
FIRST ARTICLE INSPECTION DIMENSION SHEET

| Dim | Min | Max | Go/No Go Gauge | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-----------|-----------|-----------|-----------|
| | | | | A26 | 27 226 | 28 327 | 29 428 | 30 529 |
| A | 3.611 | 3.621 | | 3.616 | 3.616 | 3.616 | 3.616 | 3.616 |
| B | 0.256 | 0.263 | | .258 | .258 | .258 | .258 | .258 |
| C | 0.315 | 0.322 | | .316 | .316 | .316 | .316 | .316 |
| D | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 |
| E | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | 1.679 |
| F | 1.357 | 1.367 | | 1.362 | 1.362 | 1.362 | 1.362 | 1.362 |
| G | 0.100 | 0.140 | | .129 | .126 | .126 | .124 | .125 |
| H | 0.210 | 0.230 | | .223 | .223 | .224 | .220 | .221 |
| I | 0.615 | 0.685 | | .680 | .680 | .680 | .680 | .680 |
| J | 2.470 | 2.510 | | 2.490 | 2.490 | 2.490 | 2.490 | 2.490 |
| K | 1.313 | 1.343 | | 1.326 | 1.326 | 1.325 | 1.326 | 1.325 |
| L | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | .188 |
| M | 0.470 | 0.530 | | .500 | .500 | .500 | .500 | .500 |
| N | 1.125 | 1.145 | | 1.142 | 1.132 | 1.134 | 1.132 | 1.132 |
| O | 0.100 | 0.180 | | .135 | .135 | .135 | .135 | .135 |
| P | 0.100 | 0.140 | | .129 | .132 | .131 | .130 | .133 |
| Q | 0.240 | 0.260 | | .243 | .246 | .246 | .247 | .248 |
| R | 0.677 | 0.697 | | .690 | .690 | .690 | .690 | .691 |
| S | 0.100 | 0.140 | | .128 | .125 | .128 | .128 | .133 |
| T | 1.565 | 1.585 | | 1.582 | 1.576 | 1.574 | 1.573 | 1.573 |
| U | 0.540 | 0.560 | | .547 | .547 | .547 | .544 | .546 |
| V | 0.912 | 0.932 | | .921 | .921 | .921 | .921 | .921 |
| W | 0.787 | 0.807 | | .797 | .797 | .797 | .797 | .797 |
| X | 5.990 | 6.010 | | 6.000 | 6.000 | 6.000 | 6.000 | 6.000 |
| Y | 4.995 | 5.005 | | 5.000 | 5.000 | 5.000 | 5.000 | 5.000 |
| Z | 0.490 | 0.510 | | .494 | .497 | .496 | .499 | .499 |
| AA | 0.312 | 0.319 | | .314 | .314 | .314 | .314 | .314 |
| AB | 0.990 | 1.010 | | 1.000 | 1.000 | 1.000 | 1.000 | 1.000 |
| AC | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 |
| AD | 0.490 | 0.510 | | .500 | .500 | .500 | .500 | .500 |
| AE | 3.745 | 3.755 | | 3.750 | 3.750 | 3.750 | 3.750 | 3.750 |
| AF | 0.235 | 0.240 | | .238 | .236 | .235 | .236 | .236 |
| AG | 0.510 | 0.515 | | .511 | .511 | .512 | .512 | .512 |
| AH | 0.100 | 0.120 | | .111 | .111 | .110 | .111 | .111 |
| Accept/Reject | | | | | | | | |

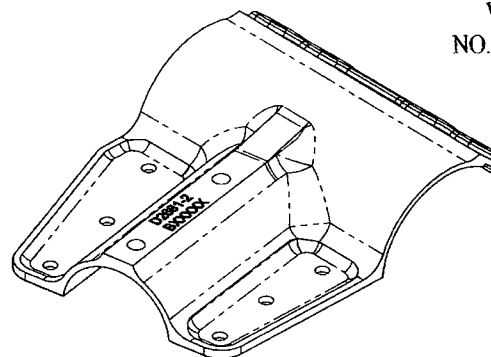
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| Measured by: | AT | Date: | 12-11-11 |
| Audited by: | OK | Date: | 12/11/12 |
| Prototype Approval: | | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------------------------|------------|----------|
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |
| G | 11.11.07 | Dimensions C and F revised | KJ | |
| H | 12.01.10 | Revised per drawing revision E | KJ | |

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 NO. 91218 MCT
 12-10-03



D2661-1 SADDLE, OUTSIDE, LH



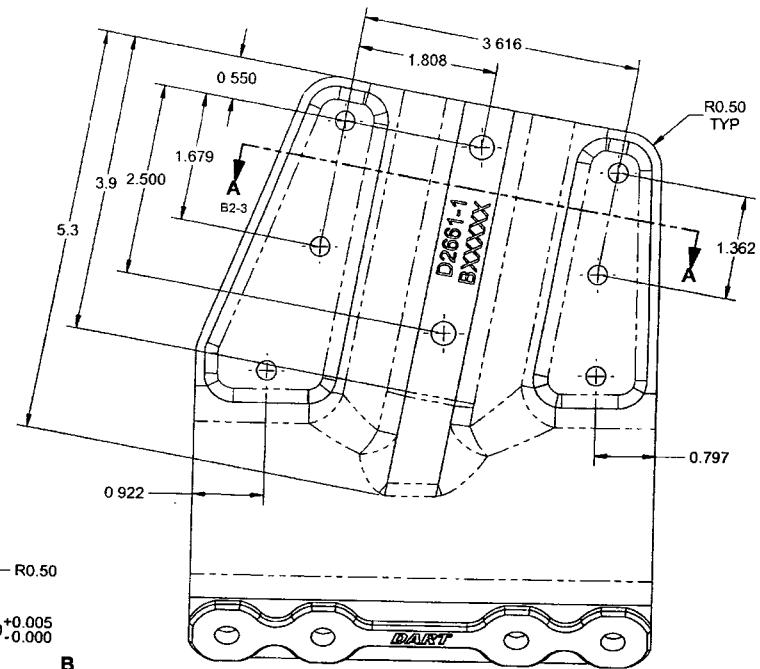
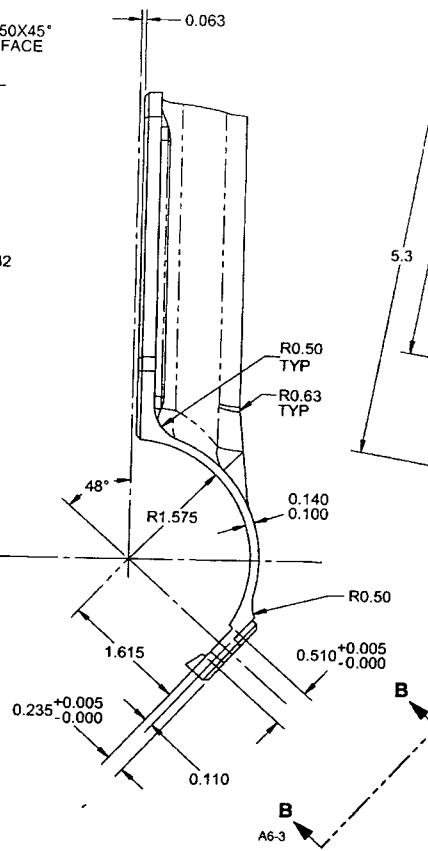
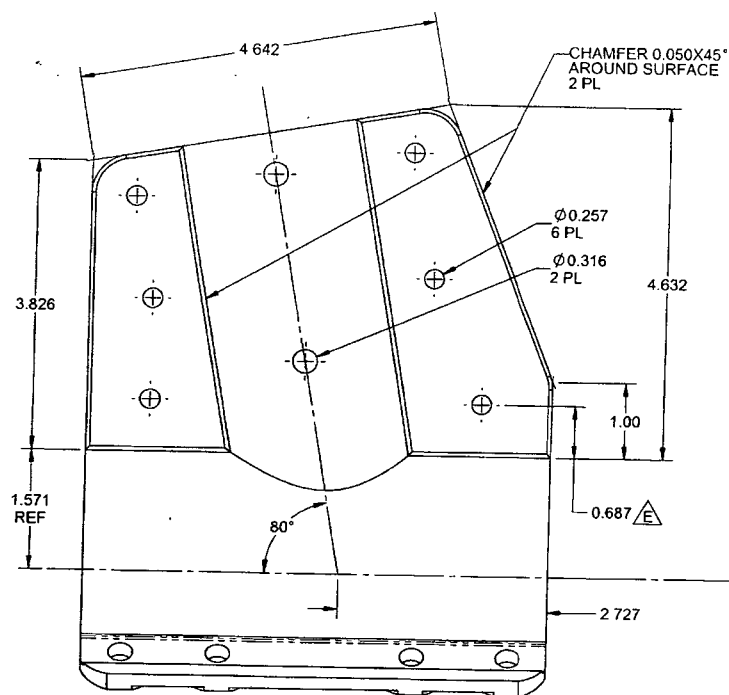
D2661-2 SADDLE, OUTSIDE, RH

RELEASED
 2011-11-16

| | | | |
|------------|---|----|----------|
| E | REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B8-4), REF NCR 11-935 | CP | 11.10.31 |
| D | R0.188 WAS R0.30, Ø0.316 WAS Ø0.313 | CB | 06.11.08 |
| C | INCORPORATE DEO 9122, 9102, 9085 | CB | 06.05.29 |
| B | ANGLE AND NOTES ADDED | KE | 97.07.11 |
| A | NEW ISSUE | DS | 07.03.25 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 11.10.31 | | |

| | |
|---|------------------------|
| DART AEROSPACE USA, INC. KENT, WA | |
| DRAWING NO. D2661 | REV. E SHEET 1 OF 5 |
| TITLE SADDLE, OUTSIDE | SCALE NTS |
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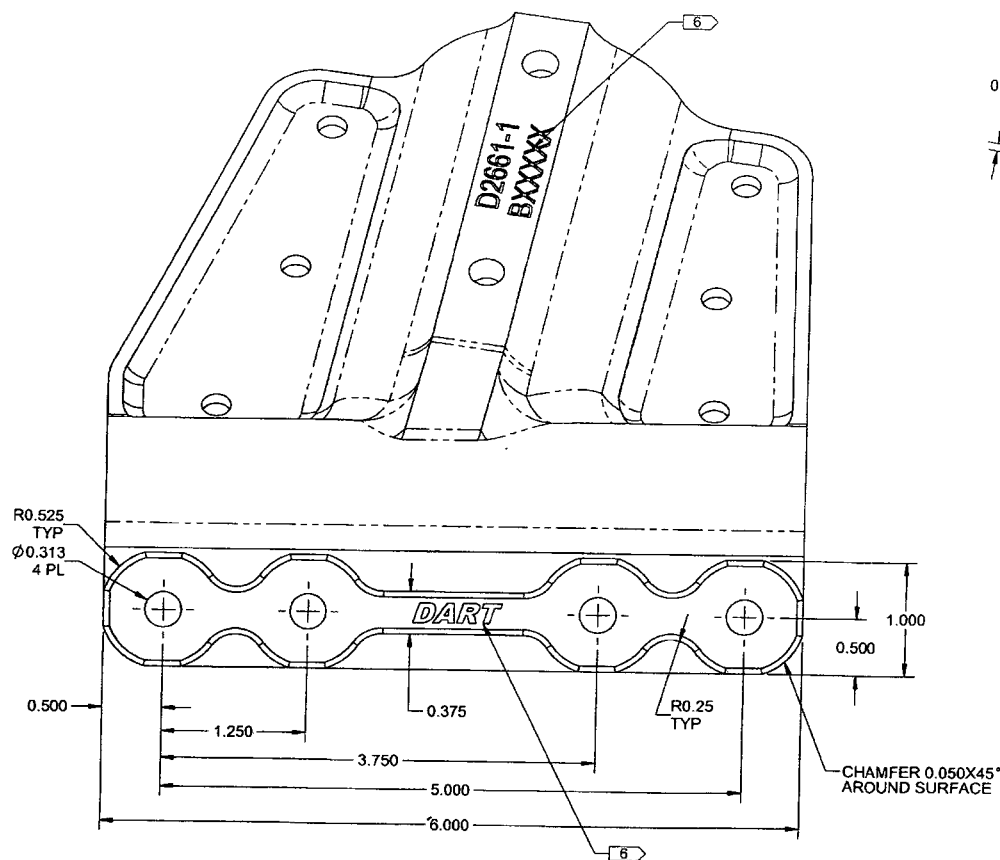
D2661-1 SADDLE, OUTSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

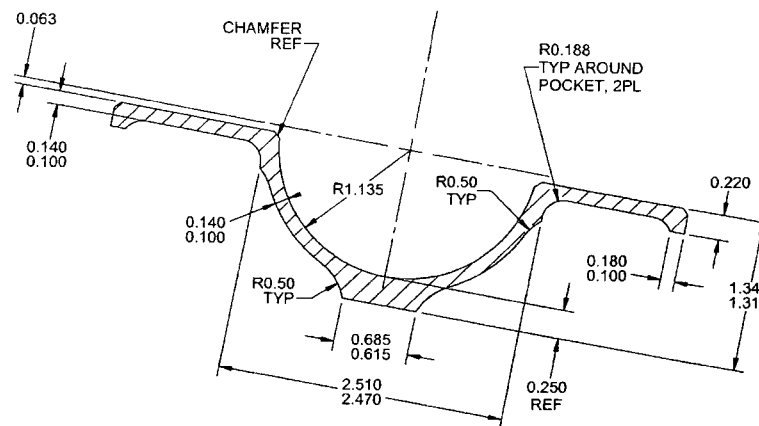
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2011-11-16

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|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE USA, INC. | |
| DRAWN | | KENT, WA | |
| CHECKED | ASS | DRAWING NO. | REV. E |
| MFG. APPR. | | D2661 | SHEET 2 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | SADDLE, OUTSIDE | NTS |
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91218



VIEW B-B
SCALE 1.5X
VIEW ROTATED

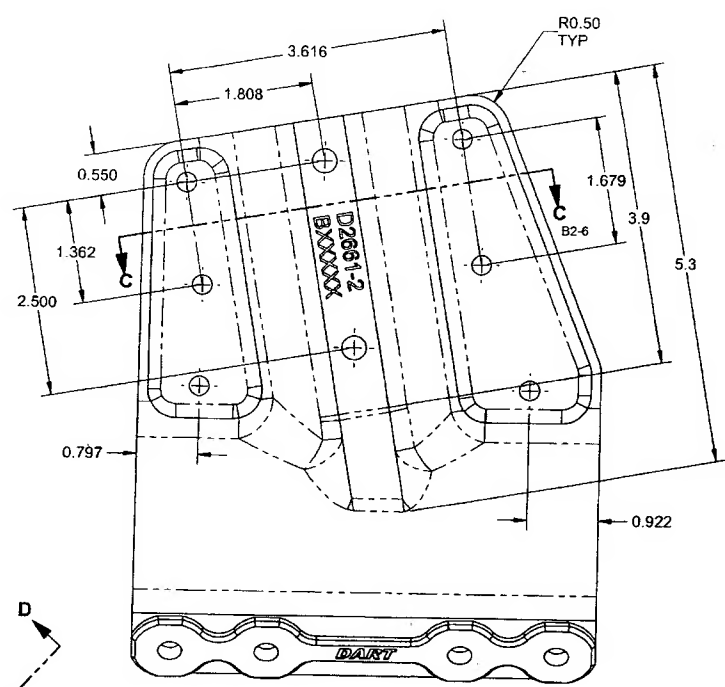
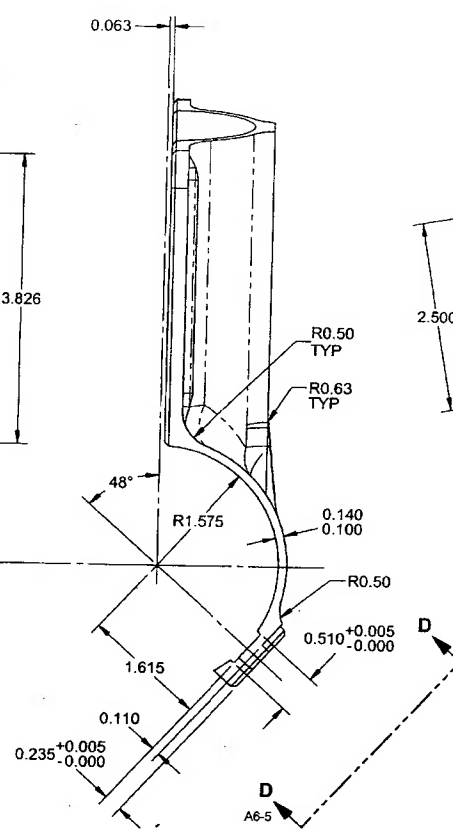
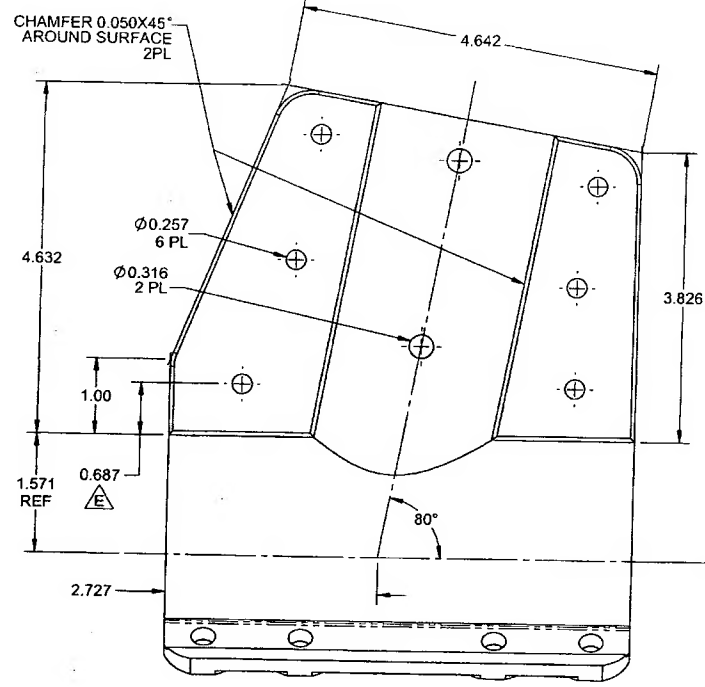


VIEW A-A
SCALE 1.5X

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2011-11-16

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|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE USA, INC. | |
| DRAWN | | KENT, WA | |
| CHECKED | | DRAWING NO. D2661 | REV. E |
| MFG. APPR. | | | SHEET 3 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | SADDLE, OUTSIDE | NTS |
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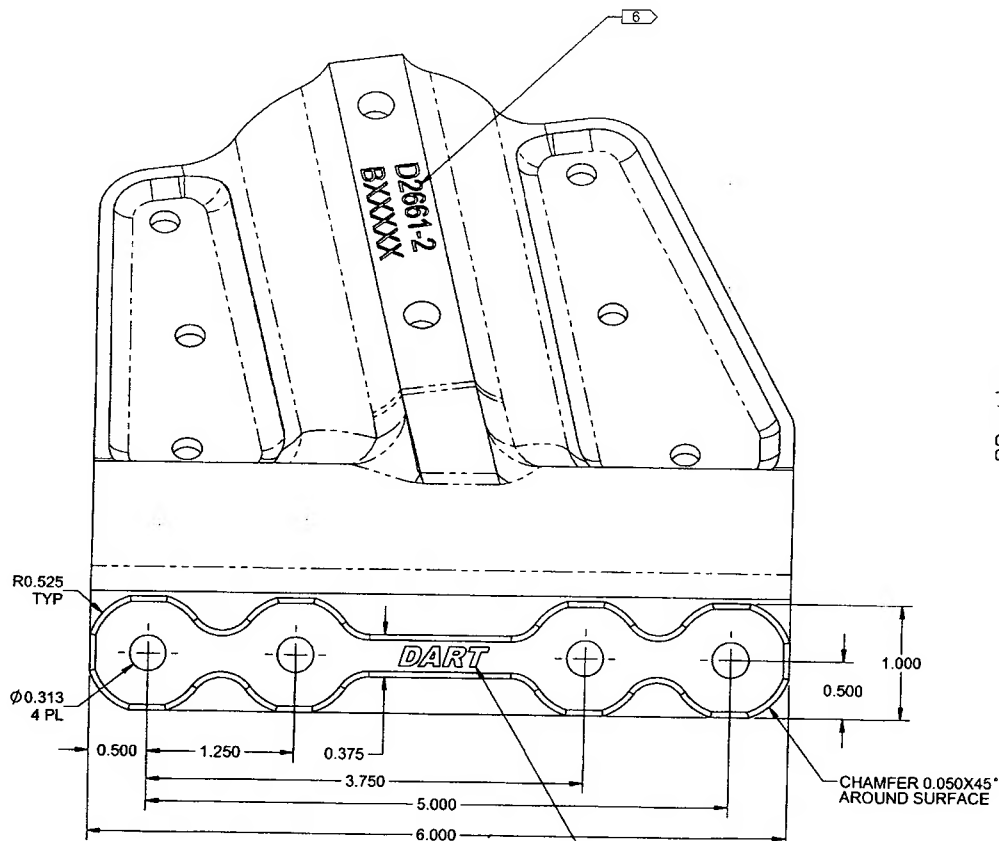
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2011-11-16

D2661-2 SADDLE, OUTSIDE, RH

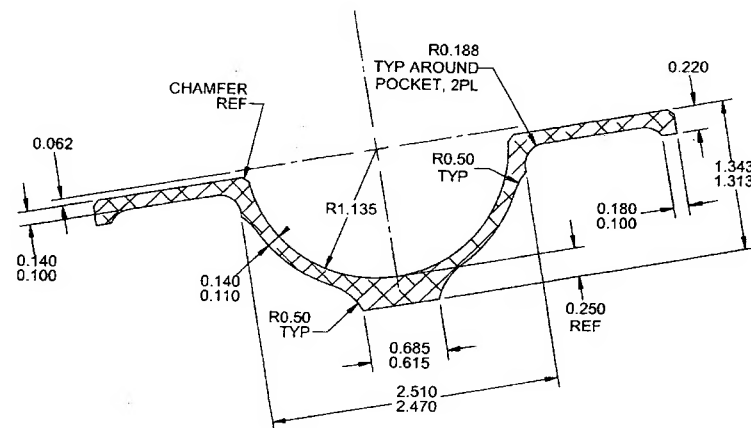
- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE USA, INC. | |
| DRAWN | | KENT, WA | |
| CHECKED | ASS | DRAWING NO. | REV. E |
| MFG. APPR. | | D2661 | SHEET 4 OF 5 |
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VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



SECTION C-C C1-4
SCALE 1.5X

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|------------|----------|--|--------------|
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| DRAWN | GP | KENT, WA | |
| CHECKED | ASS | DRAWING NO. | REV. E |
| MFG. APPR. | WAP | D2661 | SHEET 5 OF 5 |
| APPROVED | WAP | TITLE | SCALE |
| DE APPR. | WAP | SADDLE, OUTSIDE | NTS |
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